

Date: Tuesday, 12/5/2006 8:15:48 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG BRACKET		
Job Number	: 29780B					
Estimate Number	: 10339					
P.O. Number	: N/A			Part Number	: D2658	
This Issue	: 12/5/2006 S.O. No. : N/A			Drawing Number	: D2658 REV D	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: D	
Previous Run	: 29228B			Material	: N/A	
Written By	: <i>[Signature]</i>			Due Date	: 1/5/2007	
Checked & Approved By	: <i>[Signature]</i>			Qty:	40	
Comment	: Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-08-23 JLM			Um:	Each	

Additional Product

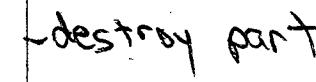
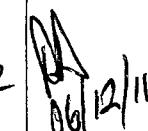
Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M1010S12GA	1010/1025/A21/6aA SHEET	
		Comment: Qty.: 0.1197 sf(s)/Unit Total : 4.7880 sf(s) 1010/1025/A21/6aA SHEET 12 GAUGE .100" THK Batch: <i>M101094</i> <i>ml 08 12 11</i> <i>(40)</i>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2858 Dwg Rev: <i>D</i> <i>ml 08 12 11</i> <i>(40)</i> Prog Rev: <i>D</i>	
		2-Deburr if necessary	<i>SAV 08:12:13</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<i>ml 08 12 11</i> <i>(40)</i>	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		<i>(40)</i>	
		Comment: SECOND CHECK	<i>(40)</i>
5.0	BRAKE NC	NC BRAKE	
		<i>(39)</i>	
		Comment: NC BRAKE 1-Deburr as required. <i>SAV 08:12:13</i> <i>(39)</i>	
		2-Bend on CNC brake using DT8254 Identify as D2658	<i>SB 04/12/18</i> <i>(39)</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/02/19
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			
06/12/11	3.0	-1 part scrap -part moved in water jet	 AS/02	 destroy part		06/12/11	 06/12/11	 06/04/12	 06/12/11

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/06/12/15

39

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 1258

c20710214

39

8.0 QC21

FINAL INSPECTION/W/O RELEASE



39

Comment: FINAL INSPECTION/W/O RELEASE

07/02/15

Job Completion



c20710214

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29780B
Description: Lug Bracket	Part Number:	D2658
Inspection Dwg: D2658	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>M. M</u>	Audited by:	<u>AS</u>	Prototype Approval:	N/A
Date:	08/12/11	Date:	08/12/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.13	New Issue	KJ/JLM	✓

DART

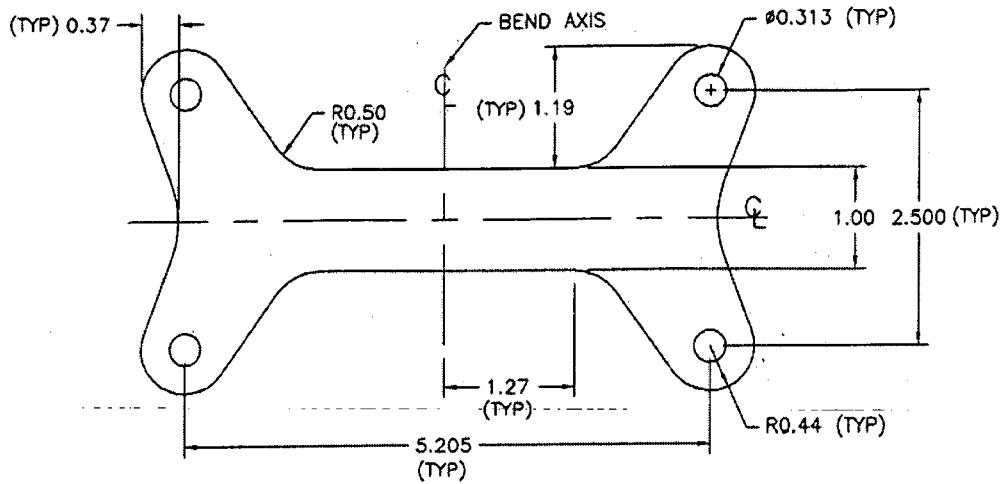
COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D D2658 SHEET 1 OF 1
DATE		TITLE	SCALE 5:9

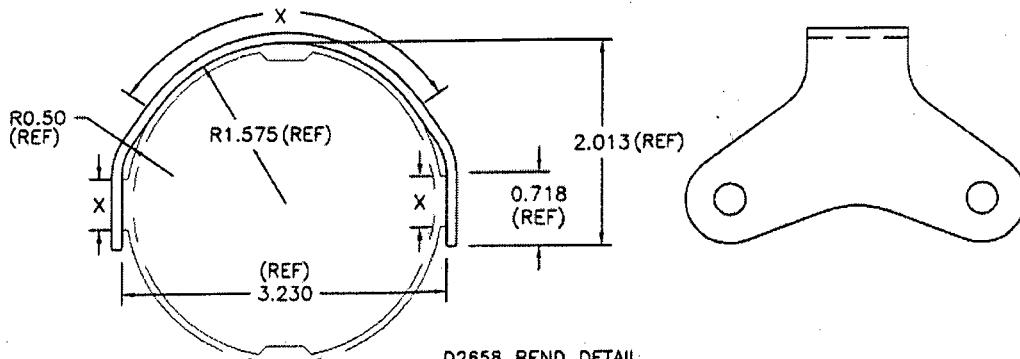
98.12.14 LUG BRACKET

A	97.11.03	NEW ISSUE
B	97.12.18	5.205 WAS 5.015, ADD TOOLING HOLE
C	98.10.23	UPDATE MATERIAL (TSR A1114)
D	98.12.14	REMOVE TOOLING HOLE (TSR A1040)

RELEASED
98.12.14 DS



D2658 FLAT PATTERN
SYMMETRICAL ABOUT BOTH CENTRE-LINES (C)



D2658 BEND DETAIL

D2658 SHOULD BE BENT SO THAT IT IS WITHIN ±0.010 OF THE OUTSIDE PROFILE
OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES
MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
INCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29780B